Work Order ID 52478

September 25, 2009 1:41:28 PM

Item ID: PB67-43001-13 GN **Accept** **Setup Start**

Revision ID: B1 **Stop**

Item Name: Aft Adjustable Blade Support Assembly

Start Date: 10/05/2009 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 10/16/2009 **Req'd Qty:** 2.00 **Customer:**

Reference:

Approvals: **Process Plan:** MF **Date:** 09-09-25 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
B67-43001	Rev B1								
100	Large Fab	0.00							
Large Fab	**Memo**	0.00							
Large Fab	1- make a 0.090" chamfer in the 1.00" hole before welding□2- assemble parts and weld as per dwg								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	**Memo**	0.00							
Quality Control									
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									

x2

09.10.14

09.10.15

2 Sorlvls

+2 0

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Revision ID: B1

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Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00				(2)			
Small Fab	**Memo**	0.00							
Small Fab	1- grind weld flush in area of PB67-43001-249 only□2- install helicol insert as per dwg SAD 09-10-14 5								
140	QC5- Inspect part completeness to step on W/O	0.00				(2)	0		
QC	**Memo**	0.00							
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	**Memo**	0.00							
Hand Finishing									

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Powdercoat Powder Coating	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00	M 18144						
	Memo 1- MASK TUBE FROM BASE TO GUSSET□START TIME: 4:45 □OVEN TEMPERATURE: 320°F □FINISH TIME: ~~4:45~~	0.00	M 09/10/19			2X			
170 QC Quality Control	QC3- Inspect Part Finish	0.00	=> M 09/10/20			X2	0		
	Memo	0.00							
180 Small Fab Small Fab	Small Fab	0.00	SAD 09-10-21			2			
	Memo 1- match drill cover to existing holes in support□2- assemble as per dwg	0.00							

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00				2 09/10/21			
	Memo	0.00				(2)	0		
200 Packaging Packaging	Identify as per dwg & Stock Location	0.00							
	Memo	0.00				09 10 21			
210 QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							
	Memo	0.00				09/10/21			

MF 09/10/21

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

September 25, 2009 1:41:28 PM

Work Order ID: 52478

Parent Item: PB67-43001-13RevB1

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 10/05/2009 **Required Date:** 10/16/2009

Comments:

Start Qty: 2.00 **Required Qty:** 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS124780 HELICAL INSERT		Purchased	No			180	Each	96.0000	2.0000	SAD	09-10-1	
				Warehouse Location		**Loc Qty**		**Loc Code**				
				Main Warehouse								
				ST		96						
					111064	96				2		
MS27039-1-10 Screw		Purchased	No			180	Each	37.0000	16.0000	Sad	09-10-1	
				Warehouse Location		**Loc Qty**		**Loc Code**				
				Main Warehouse		7m11 2828	×	16				
				ST		37						
					111425	37						
NAS1149F0316P WASHER		Purchased	No			100	Each	124.0000	16.0000	SAD	09-10-1	
				Warehouse Location		**Loc Qty**		**Loc Code**				
				Main Warehouse								
				ST		124						
					111117	119				16		
					111124	5						
PB67-43001-249RevB1 Inner Tube Bushing		Manufactured	No			100	Each	0.0000	2.0000	SAD	09-10-1	

B52480 × 2

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Picklist Print

September 25, 2009 1:41:28 PM

Work Order ID: 52478

Parent Item: PB67-43001-13RevB1

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 10/05/2009 **Required Date:** 10/16/2009

Comments:

Start Qty: 2.00 **Required Qty:** 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
PB67-43001-253RevB1		Manufactured	No			100	Each	12.0000	2.0000			
Gusset												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	12	
44983	12	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
PB67-43001-254RevB1		Manufactured	No			100	Each	2.0000	2.0000			
Gusset												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse	B52481 x 2	
ST	2	
44982	2	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
PB67-43001-255RevB1		Manufactured	No			100	Each	4.0000	2.0000			
Inner Tube												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	4	
43071	4	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
PB67-43001-67RevB1		Manufactured	No			130	Each	0.0000	2.0000			
PB67-43001-67												

B52634 x2

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W/O:		WORK ORDER CHANGES					
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Work Order ID: 52478

Parent Item: PB67-43001-13RevB1

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 10/05/2009 **Required Date:** 10/16/2009

Comments:

Start Qty: 2.00 **Required Qty:** 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
PB67-43001-69RevB1		Manufactured	No			180	Each	1.0000	2.0000			
90 Degree Cover Plate												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	1	
45762	1	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
PB67-43001-83RevB1		Manufactured	No			180	Each	6.0000	2.0000			
PB67-43001-83												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	6	
47042	6	

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DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

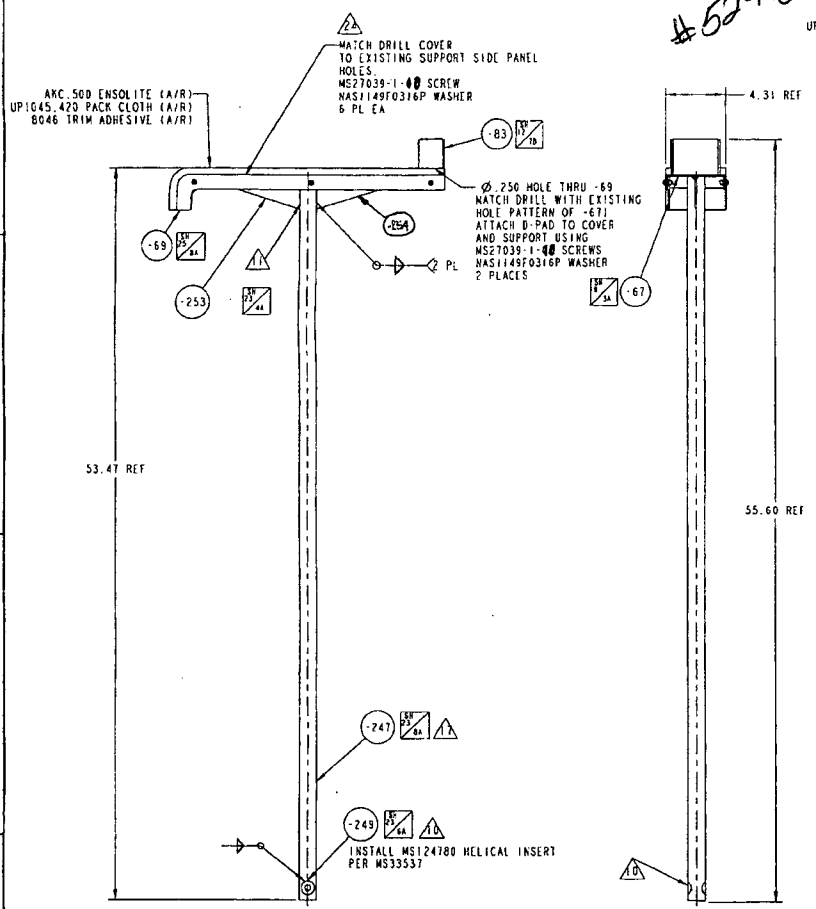
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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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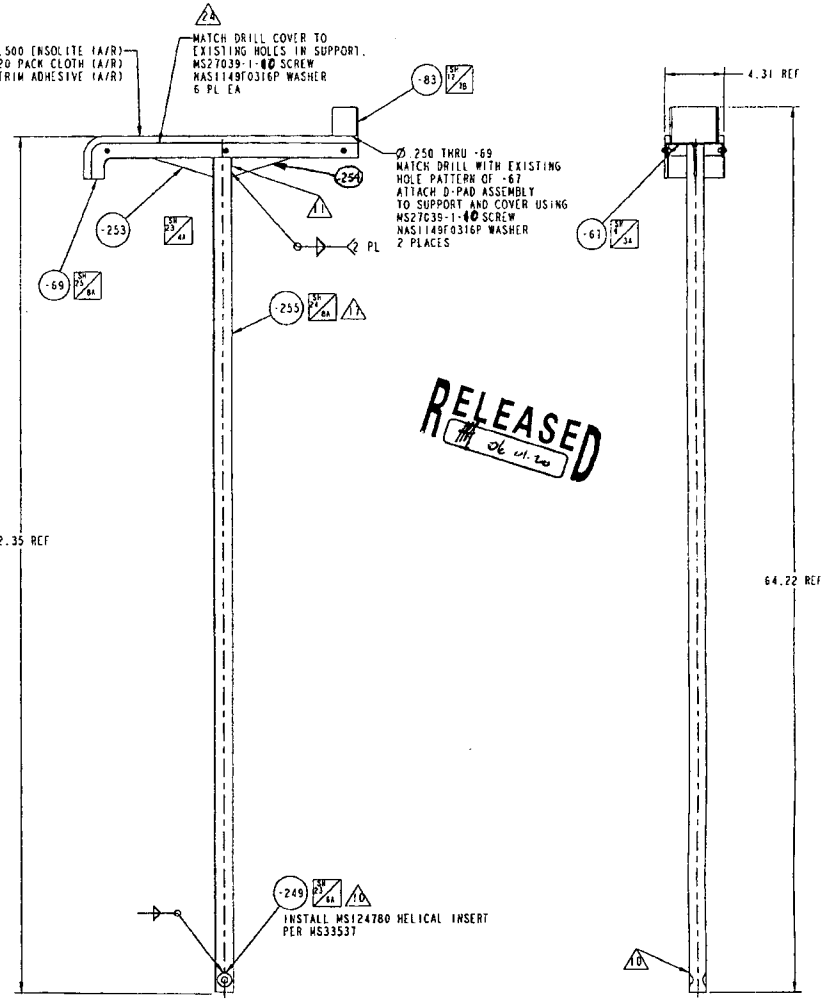
NOTE: Date & initial all entries

#52418



① -11 FWD ADJUSTABLE BLADE SUPPORT ASSY

SCALE 0.250



① -13 AFT ADJUSTABLE BLADE SUPPORT ASSY

SCALE 0.250

RELEASED 06 ul. 20

PREMIER AVIATION, INC.
2021 Aviation Parkway, Grand Prairie, Texas 75052

SIZE	CODE IDENT NO.	DWG NO.	REV.
D	0SUV8	B67-43001	G

SCALE: WT: SHEET 8 OF 45

ORIGINAL

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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